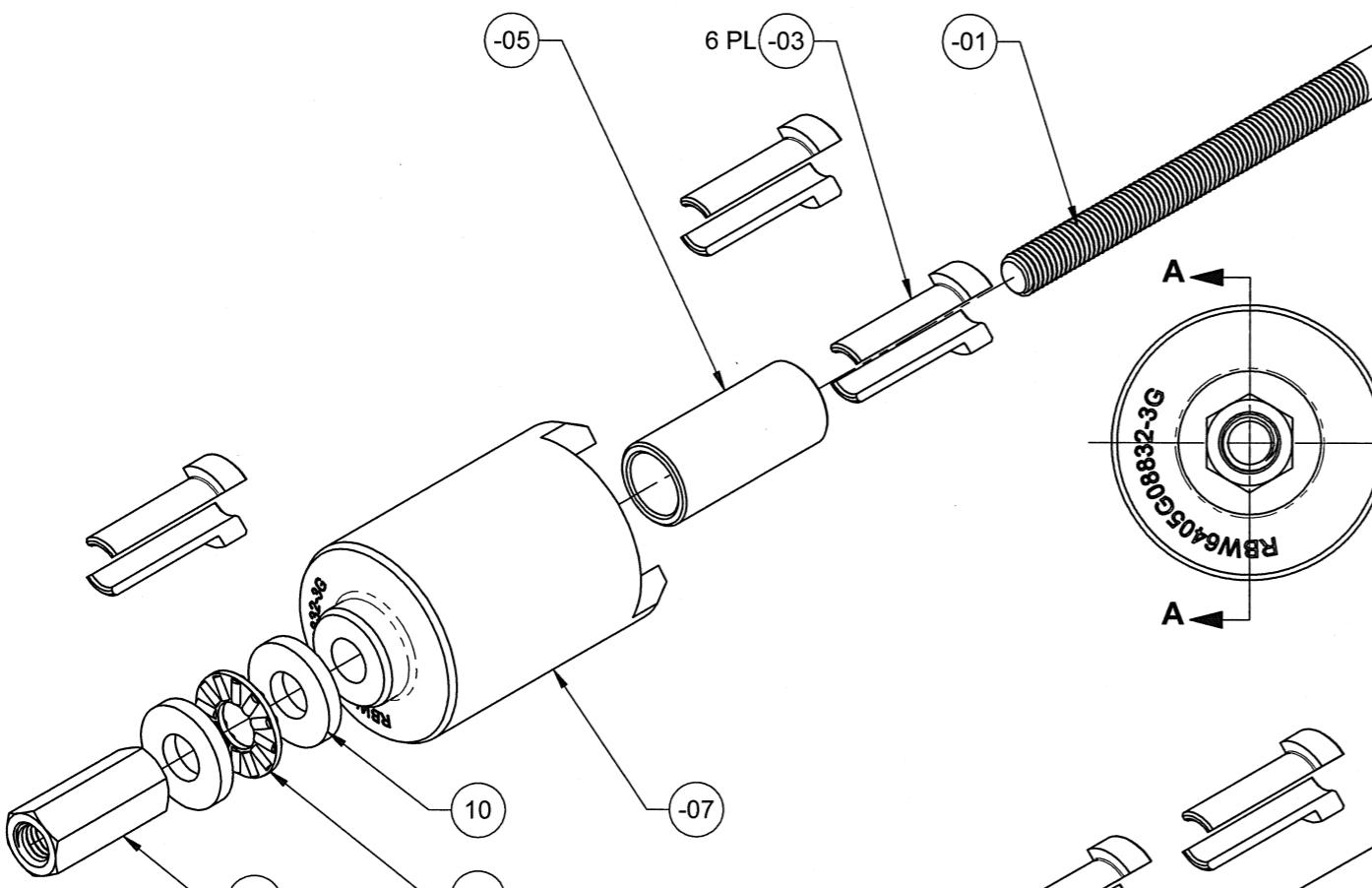
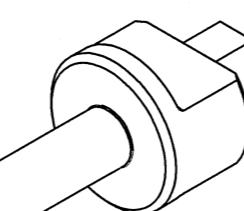
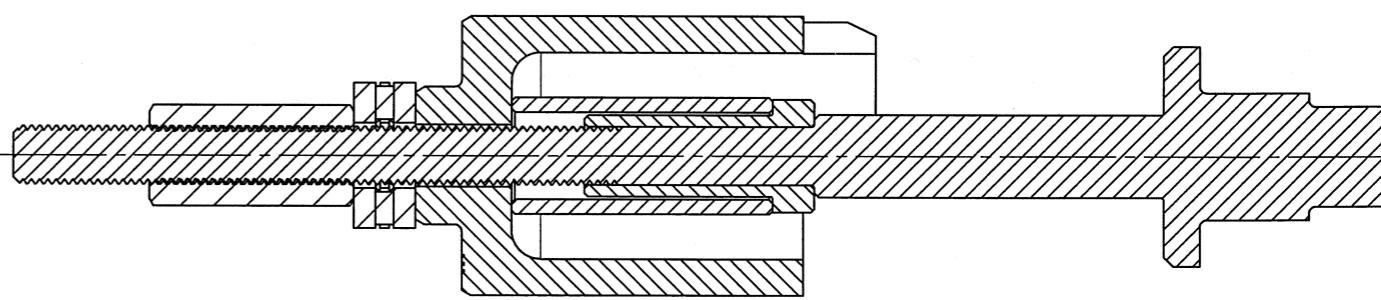
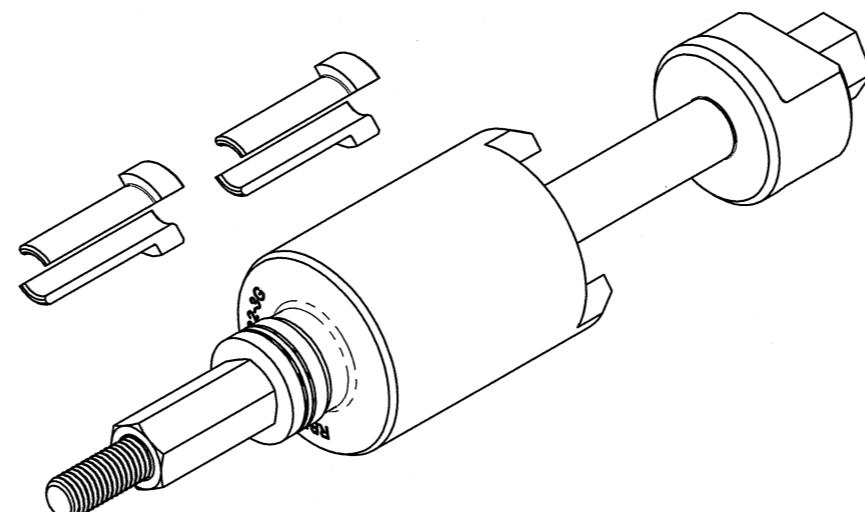


ITEM #	QTY	PART #	PART TITLE
-01	1	RBW6405G08832-3G-01	INSTALL ROD
-03	6	RBW6405G08832-3G-03	KEEPERS
-05	1	RBW6405G08832-3G-05	LOCK TUBE
-07	1	RBW6405G08832-3G-07	RECEIVER
8	1	McMaster#90264A440 OR EQUIV	ZINC PLATED STEEL COUPLING NUT 1/4"-28 X 7/8" LG.
9	1	NTA-411 OR EQUIV	NEEDLE ROLLER THRUST BEARING 1/4" ID X 11/16" OD X 5/64" THK
10	2	TRC-411 OR EQUIV	THRUST WASHER 1/4" ID X 11/16" OD X 3/32" THK



RBW6405G08832-3G TAIL ROTOR BUSHING INSTALL TOOL

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 8 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SEE PREVIOUS PDFs FOR OLDER REVs
TEMPLATE UPDATED PER HBY STANDARDS
ITEM 13 MSC#6482082 CHANGED FOR ITEM 8 McMaster#90264A440
ITEM 09 TIMKEN NTA-411 CHANGED FOR ITEM 9 NTA-411 OR EQUIV
ITEM 11 TIMKEN TRC-411 CHANGED FOR ITEM 10 TRC-411 OR EQUIV
ITEM -03 QTY 2 CHANGED FOR QTY OF 6
ITEM -01 DIMENSION 2.61 CHANGED FOR 2.62, DIMENSION 3.44 REF CHANGED FOR 3.44, DIMENSION 1/4"-28 UNF -2A CHANGED FOR 1/4"-28 UNF, DIMENSION R0.008" MAX 2 PL ADDED, DIMENSION R0.03 TYP ADDED, CENTER DRILL NOTE ADDED, DIMENSION .55/.54 CHANGED FOR 0.545, DIMENSION .433/.424 HEX CHANGED FOR 0.428 HEX, ENGRAVING REMOVED, MATERIAL 4140/4142 Q&T CHANGED FOR 4140 (28-32 RC), FINISH ZINC PLATE CHANGED FOR BLACK OXIDE, DIMENSION .03X45° CMF CHANGED FOR 0.04 X 45.0° CMF 3 PL, DIMENSION 0.02 X 45.0° CMF ADDED
ITEM -03 MATERIAL AISI 4140/4142 Q&T CHANGED FOR 4140 (28-32 RC), FINISH ZINC PLATE CHANGED FOR ZINC PLATE YELLOW, DIMENSION R0.008" MAX ADDED, DIMENSION .02X45° CMF CHANGED FOR 0.02 X 45.0° CMF 4 PL
ITEM -05 MATERIAL 7075-T6 CHANGED FOR 6061-T6/7075-T6, FINISH CLEAR ANODIZE CHANGED FOR RED ANODIZE, DIMENSION Ø .500 CHANGED FOR Ø 0.500 +0/-0.005"
ITEM -07 MATERIAL 7075-T6 CHANGED FOR 6061-T6/7075-T6, FINISH CLEAR ANODIZE CHANGED FOR RED ANODIZE, ENGRAVING S/N REMOVED, DIMENSION R.150 MAX CHANGED FOR R0.13, DIMENSION Ø .270 CHANGED FOR Ø 0.266

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	JFC	REV. E	
APPROVED	VIP	RBW6405G08832-3G	
DATE 2019-08-20		SHEET 1 OF 5	
TITLE TAIL ROTOR BUSHING INSTALL TOOL		SCALE NTS	
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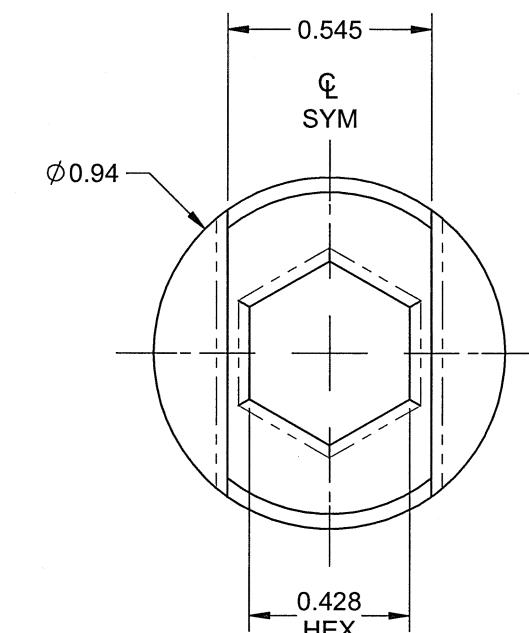
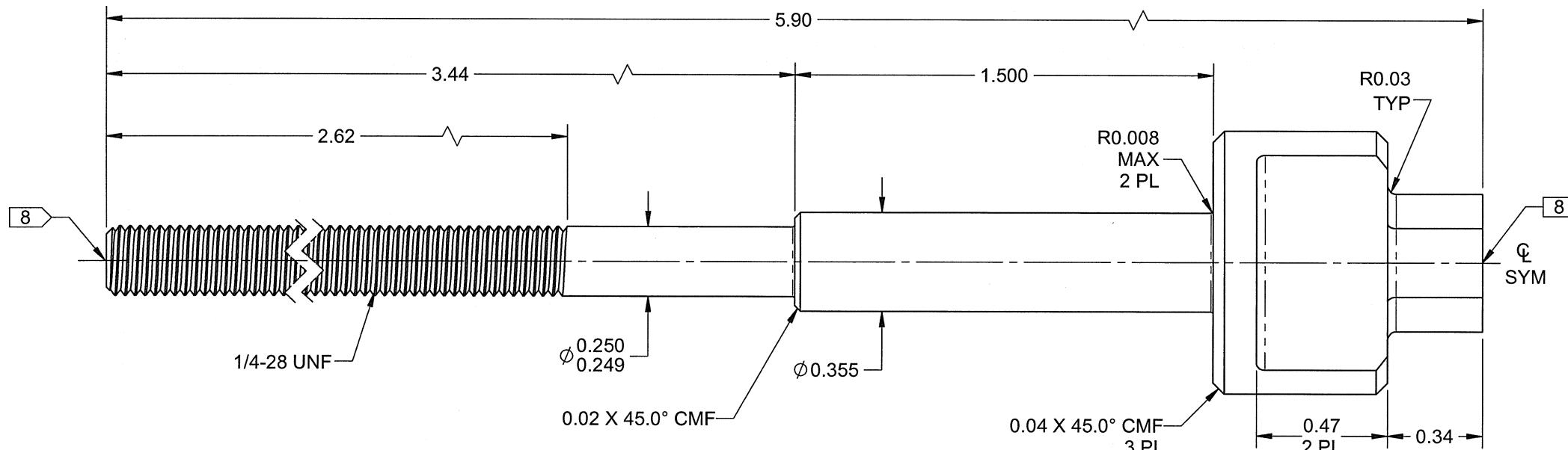
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RBW6405G08832-3G-01 INSTALL ROD

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	KPT				
MFG. APPR.	JFC				
APPROVED	<i>[Signature]</i>				
TOOL PART #	RBW6405G08832-3G				
DATE	2019-08-20				
TITLE	TAIL ROTOR BUSHING INSTALL TOOL				
SCALE	NTS				
REV. E	SHEET 2 OF 5				
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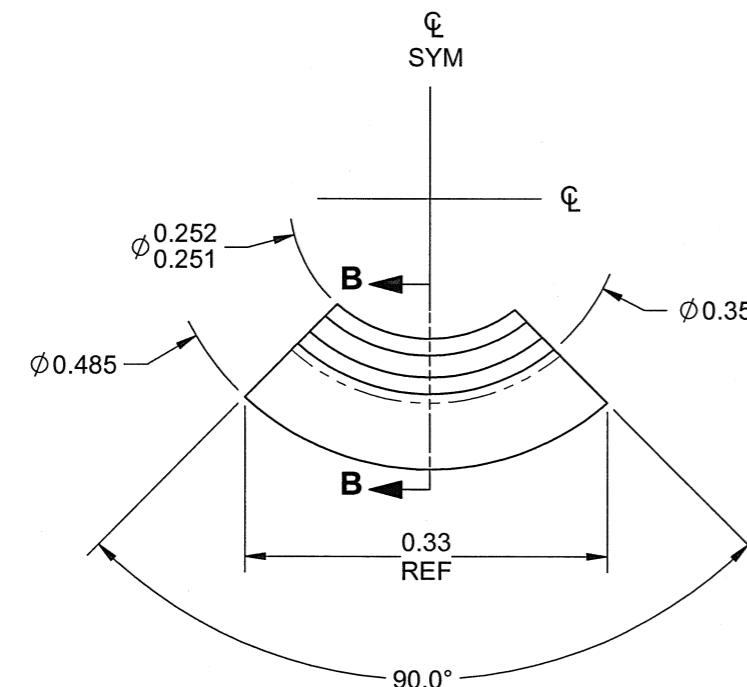
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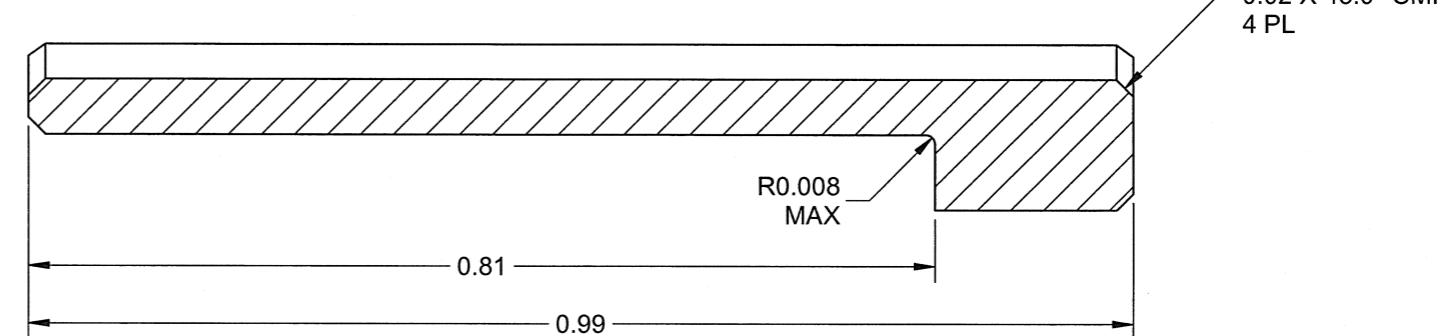
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RBW6405G08832-3G-03 KEEPERS

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SECTION B-B

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFG		
APPROVED	<i>[Signature]</i>		
DATE	2019-08-20		
TOOL PART #	RBW6405G08832-3G		REV. E
TITLE	TAIL ROTOR BUSHING INSTALL TOOL		SHEET 3 OF 5
SCALE			NTS

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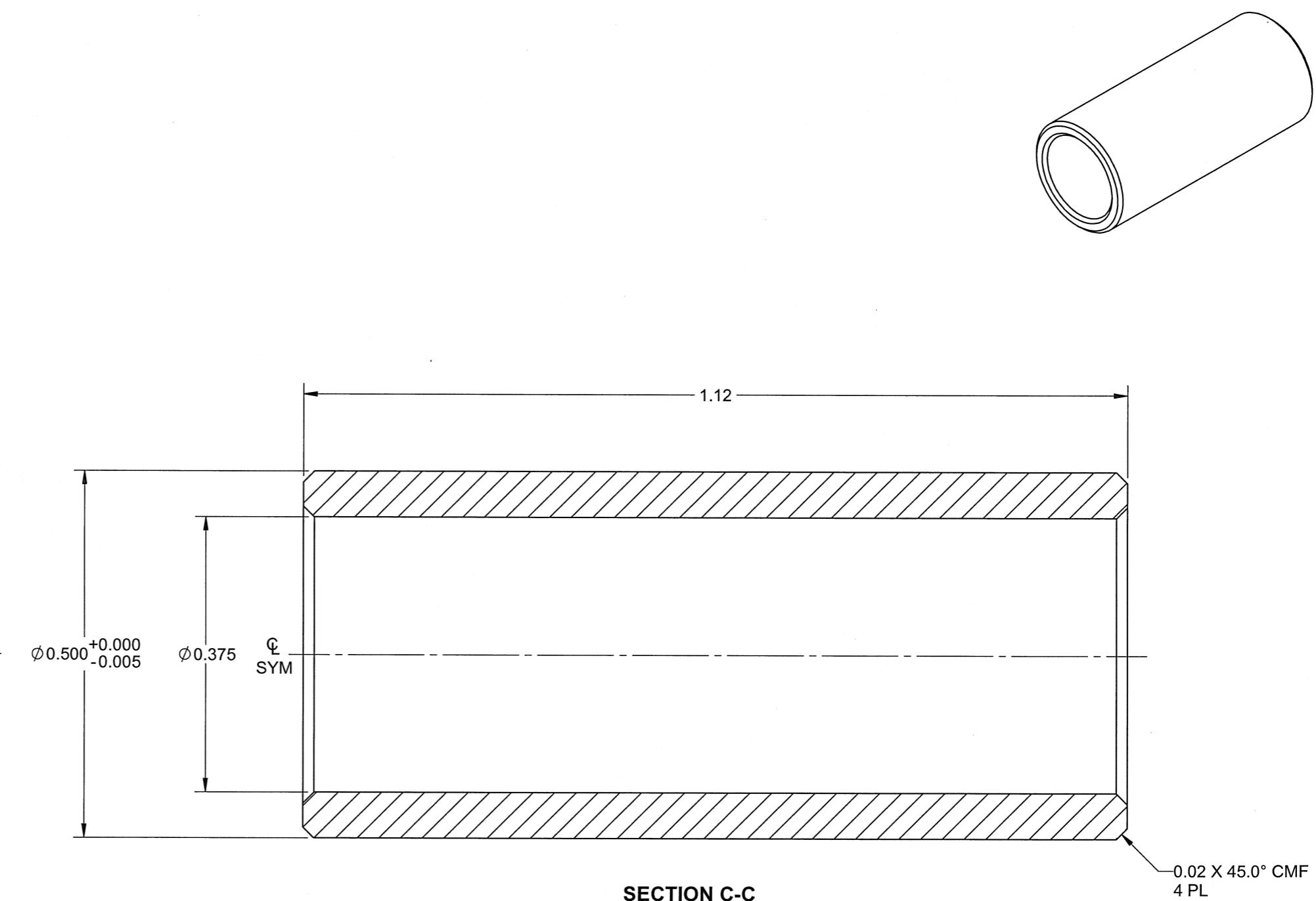
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RBW6405G08832-3G-05 LOCK TUBE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A



SECTION C-C

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	JFC	
APPROVED	WJ	
TOOL PART #	RBW6405G08832-3G	REV. E
TITLE	TAIL ROTOR BUSHING INSTALL TOOL	SHEET 4 OF 5
SCALE	NTS	
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DATE 2019-08-20

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